

Work Order ID 63268

Wednesday, October 27, 2010 9:06:13 AM

Page 1

Item ID: D212-725-1-129F

Accept

Revision ID:

Item Name: Gusset

Start Date: 10/27/2010 Start Qty: 2.00

Required Date: 11/30/2010 Req'd Qty: 2.00

Reference:

Approvals:

Process Plan:

Date: 10/27

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D212-725-1

Rev G

100

0.00



Waterjet

FLOW CNC Waterjet

304 .040

Memo

1-Cut as per Dwg

Dwg Rev: G

Prog Rev: G

2-Deburr if necessary

0.00

10-10-28

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

10-10-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 63268

Wednesday, October 27, 2010 9:06:13 AM

Page 2

Item ID: D212-725-1-129F

Accept

Setup Start

Revision ID:

Stop

Item Name: Gusset

Start Date: 10/27/2010 Start Qty: 2.00

Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8 10/10/28

T2

130

Bend as per dwg

0.00



Brake NC

Memo

0.00

Brake NC

JB 10/10/28

2

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S 10/10/28

T2

-129

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 63268

Wednesday, October 27, 2010 9:06:13 AM

Page 3

Item ID: D212-725-1-129F

Accept

Setup Start

Revision ID:

Stop

Item Name: Gusset

Start Date: 10/27/2010 Start Qty: 2.00

Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Chemical Conversion Coat per QS!005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

n/a

Part is made
of Stainless
Steel
8.10.10/28

160

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: 386

0.00

Packaging

Memo

0.00

Packaging

Curry (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 63268

Wednesday, October 27, 2010 9:06:13 AM

Page 4

Item ID: D212-725-1-129F

Accept

Setup Start

Revision ID:

Stop

Item Name: Gusset

Start Date: 10/27/2010 Start Qty: 2.00

Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/29

10-10-28
(2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, October 27, 2010 9:06:17 AM

Page 1

Work Order ID: 63268



Parent Item: D212-725-1-129F



Parent Item Name: Gusset



Start Date: 10/27/2010

Required Date: 11/30/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.07.19 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA  304/316 .040 Sheet		Purchased	No			100	sf	166.2000	0.1421	0.299158			
													

1B10-10-28

Location

Loc Qty

Loc Code

MAT

162.2

115762

10.2

115953

152

115953

MAT20

4

113062

1.398

115440

2.602

②

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DAW-725-1-129F

X	First Article	X	Prototype
---	---------------	---	-----------

Measured by: <u>LB</u>	Audited by: <u>S</u>	Prototype Approval:
Date: <u>10-10-29</u>	Date: <u>10/10/29</u>	Date:

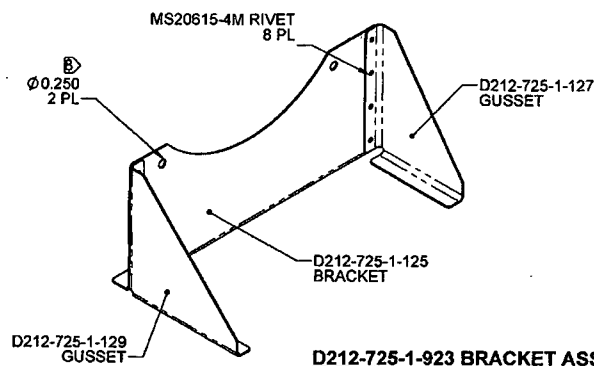
H:\FORMS\Quality Assurance\approved QA\FAI revD

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

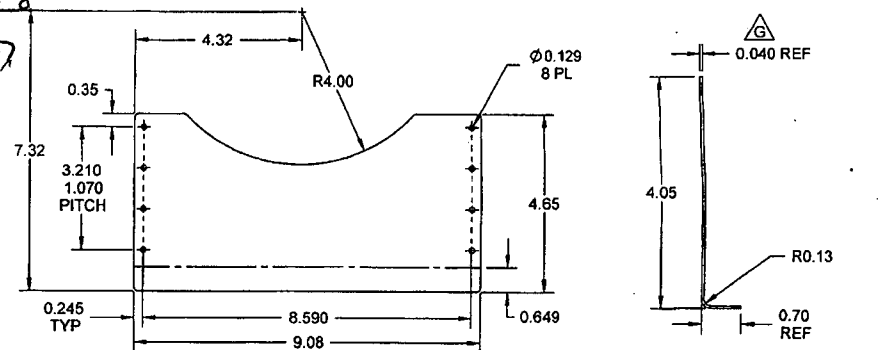
WITHOUT NOTICE
WORK ORDER

NO. 103268

pl 10-10-27

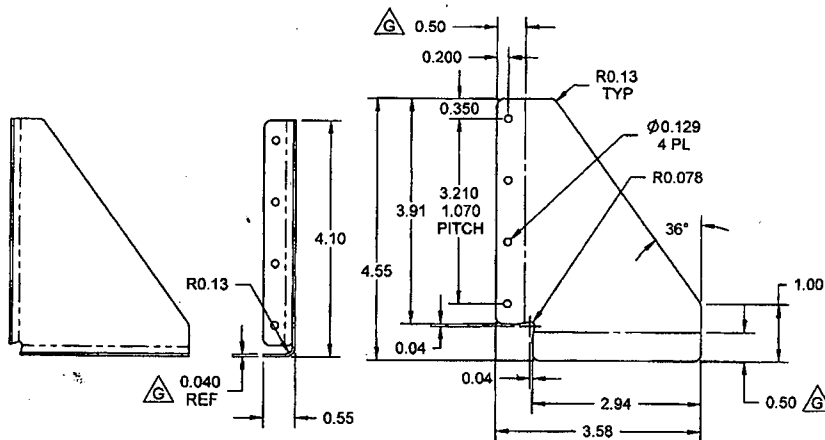


D212-725-1-923 BRACKET ASSEMBLY

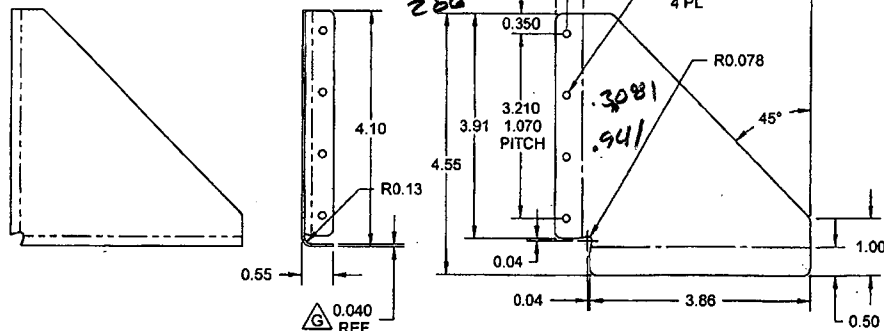


D212-725-1-125F FLAT PATTERN

D212-725-1-125 BRACKET
(MAKE FROM D212-725-1-125F FLAT PATTERN)



D212-725-1-127F FLAT PATTERN



D212-725-1-129F FLAT PATTERN

D212-725-1-127 GUSSET
(MAKE FROM D212-725-1-127F FLAT PATTERN)

D212-725-1-129 GUSSET
(MAKE FROM D212-725-1-129F FLAT PATTERN)

RELEASED

12-07-71

D212-725-1-125/1-127/1-129 NOTES:

- 1) MATERIAL: AISI 304 STAINLESS STEEL ANNEALED 2B FINISH SHEET 0.040 (19 GAUGE) THICK
PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240
REF DART SPEC M304S19GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY ASSEMBLY WITH DART P/N D212-725-1-923 USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: N/A
- 8) TRANSFER Ø0.250 HOLES FROM FIRE EXTINGUISHER BOTTLE

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. G
MFG. APPR.	RF	D212-725-1	SHEET 41 OF 84
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	212S DETAIL PARTS	NTS
DATE	10.02.12	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND UNCLASSIFIED. ANY DISSEMINATION OF THE EXPRESS OR IMPLIED CONTENTS OF THIS DOCUMENT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries